

**Work Order ID 70900**

Friday, June 17, 2011 7:35:27 AM



Page 1

Item ID: D3234-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *K*Date: *11-06-17* Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3234	Rev B

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet  
*2024 .050*

Memo

0.00

*B11-6-23*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

*B11-6-23*

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

*8 w/06/173**(+7)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 70900**

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Friday, June 17, 2011 7:35:27 AM

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Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

2 BL 11-6-23

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BL 11-6-23

150

Identify as per dwg & Stock Location: ST233

0.00



Packaging

Memo

0.00

Packaging

C fb ② 11/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

**Work Order ID 70900**

Friday, June 17, 2011 7:35:27 AM



Page 3

Item ID: D3234-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/16/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC

Quality Control

Memo

0.00

*11/16/21**MF*  
11-06-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Friday, June 17, 2011 7:35:33 AM

Page 1

Work Order ID: 70900



Parent Item: D3234-1



Parent Item Name: Doubler

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-08-14 JLM Verified By:EC  
IPP Rev:B 08-12-18 as per ECN08-582 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased		No		100	sf	122.3000	0.579	1.218947	3,		

2024-T3 .050 sheet



Location	Loc Qty	Loc Code
MAT22	122.3	
117684	122.3	

117684

3

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	709000
Description: Doubler	Part Number:	D3234-1
Inspection Dwg: D3234	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: *P*

**Audited by:**

### Prototype Approval:

NA

Date: 11-6-23

Date: 16/06/173

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	09.05.04	Dimensions update per Rev B	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

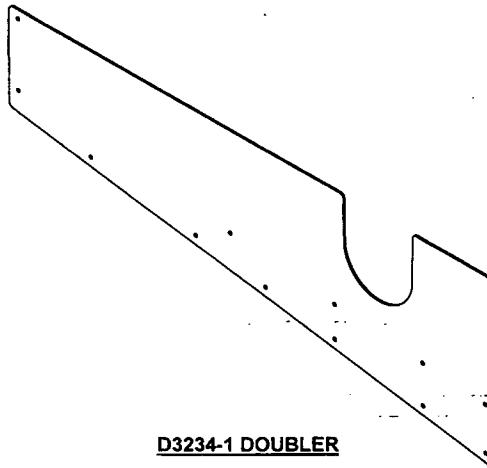
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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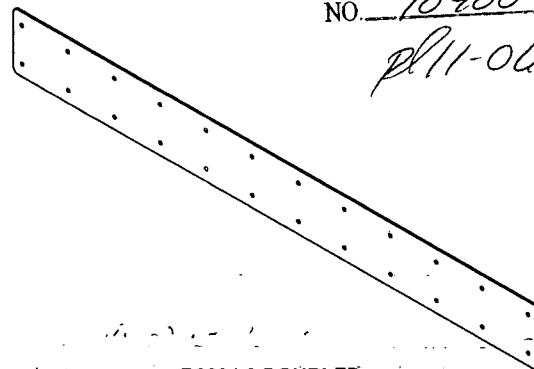
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

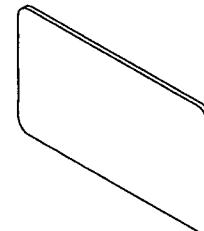
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 10900  
*PL11-06-17*



D3234-1 DOUBLER



D3234-3 DOUBLER



D3234-5 SPACER

**RELEASED**  
*(06/12/15 JV)*

NOTES:

1) MATERIAL: -1 & -3: 2024-T3 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-2504 OR AMS 4037  
REF DART SPEC M2024T3S.050

-5: 5052-H32 ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-2508 OR AMS 4016  
REF DART SPEC M5052H32S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3234-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: -1: 0.30 lbs  
-3: 0.15 lbs  
-5: 0.01 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. PARTS FULLY DIMENSIONED. NO PHYSICAL CHANGES MADE TO PARTS. REASON: REF PAR 08-029.	AJS	08.11.24
A	NEW ISSUE	CP	03.11.19
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A	DRAWING NO.	REV. B
MFG. APPR.	NA	D3234	SHEET 1 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	NA	DOUBLER	NTS
DATE	08.11.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

A

D

C

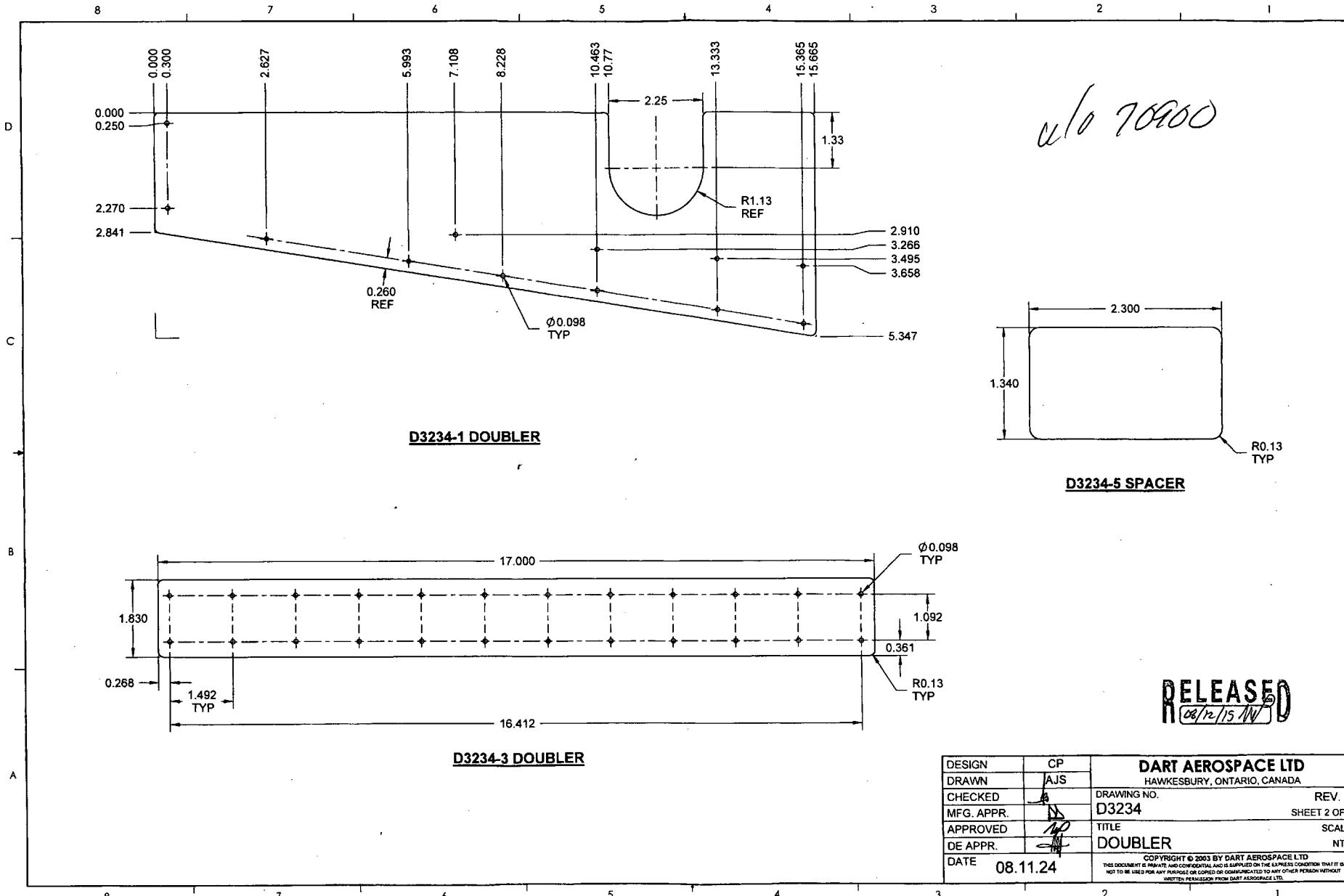
B

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NOTE: Date & initial all entries



4/10 70900

**D3234-5 SPACER**

RELEASED  
08/12/15 M

DESIGN	CP	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>A</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>AS</u>	D3234	SHEET 2 OF 2	
APPROVED	<u>NO</u>	TITLE	SCALE	
DE APPR.	<u>MM</u>	DOUBLER	NTS	
DATE	08.11.24	COPYRIGHT © 2003 BY DART AEROSPACE LTD		
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